

Date: Wednesday, 4/4/2007 9:03:33 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FITTING	
Job Number	: 31609				
Estimate Number	: 10844				
P.O. Number	: N/A		Part Number	: D2249041	
This Issue	: 4/4/2007	S.O. No.	: N/A		Drawing Number : D2249 REV. E
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: E	
Previous Run	: 31485		Material	: N/A	
Written By			Due Date	: 4/22/2007 Qty: 10 Um: Each	
Checked & Approved By			<i>KJ/07.04.04</i>		
Comment	: Est: D 05.02.04 Added Step 9 KJ/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	31609A	LUG	
	Comment: Sub-Component LUG D2249-1 B <i>31609 6x / B 31485 4x / B 31609 13x</i>		
2.0	31609B	LUG	
	Comment: Sub-Component LUG D2249-3 B <i>31031B 5x B 22498 5x</i>		
3.0	31609C	GUSSET	
	Comment: Sub-Component GUSSET D2249-5 B <i>22498 14x B 31609 6x</i>		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
	Comment: LARGE FABRICATION RESOURCE 1 Weld as per Dwg D2249 and QSI 004	<i>8/07/08/22</i>	<i>10x</i>
5.0	QC5/9	WELD INSPECTION	
		<i>QC9 07/08/23</i>	
	Comment: WELD INSPECTION	<i>QC5 07/08/23</i>	
6.0	POWDER COATING	POWDER COATING	
		<i>m105068</i>	
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3	<i>FL 07/08/24</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/08/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:03:33 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 31609

Part Number: D2249041

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



U 07/08/24

Comment: INSPECT POWDER COAT

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EJ 07/08/24 (10)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

07/08/27

Job Completion



U 07/08/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

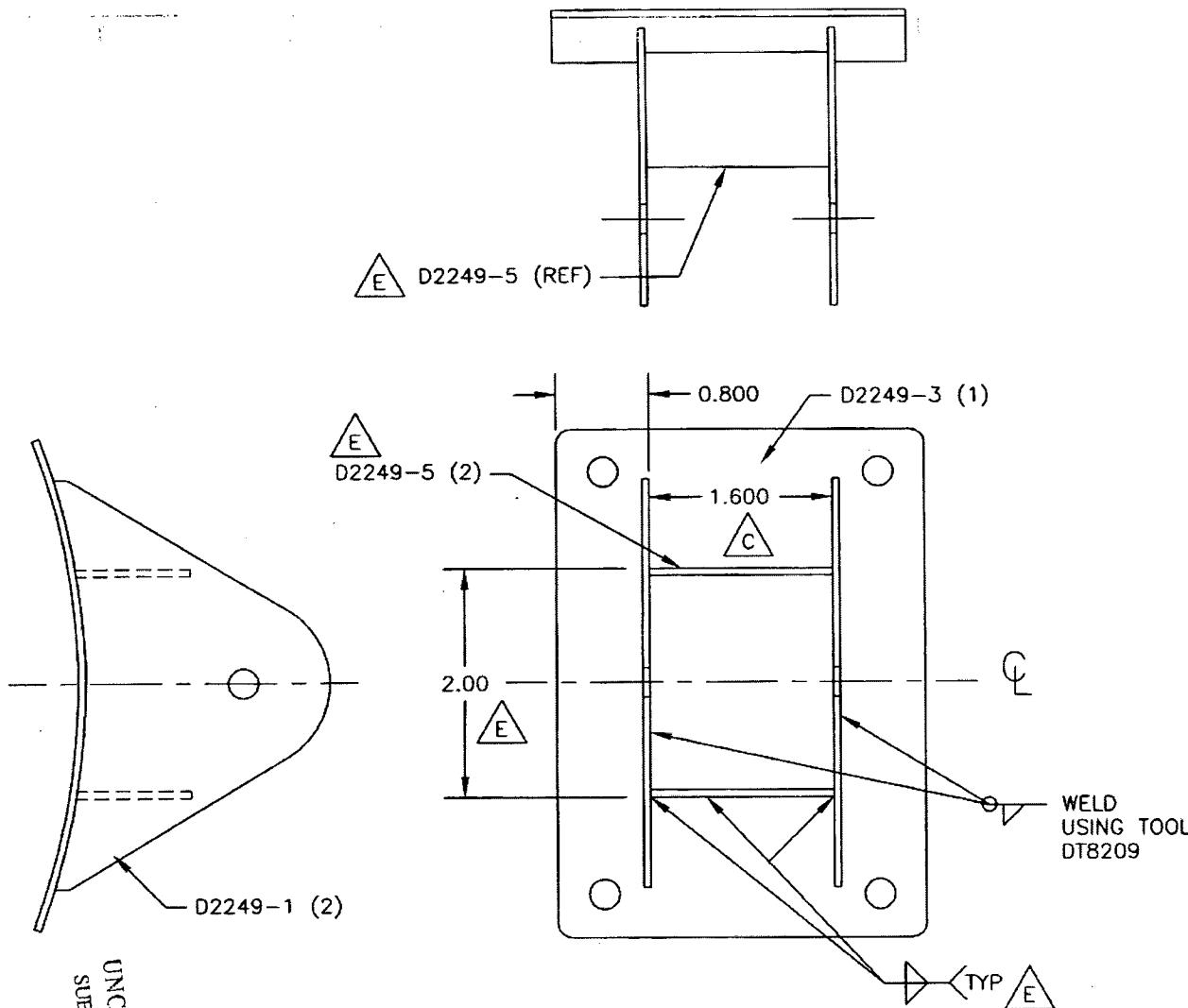
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**99.10.12
KCE

DESIGN	DRAWN BY	DART AEROSPACE LTD
<i>KE</i>	<i>RF</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. E
<i>KE</i>	<i>M</i>	DRAWING NO.
		D2249
DATE	TITLE	SHEET 1 OF 4
99.09.20	FITTING	SCALE
A	94.06.20 NEW ISSUE	NTS
B	95.11.30 DIMENSION CHANGE	
C	95.12.14	
D	98.04.30 $\phi 0.261$ WAS $\phi 0.257$ (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20 ADDED GUSSET	

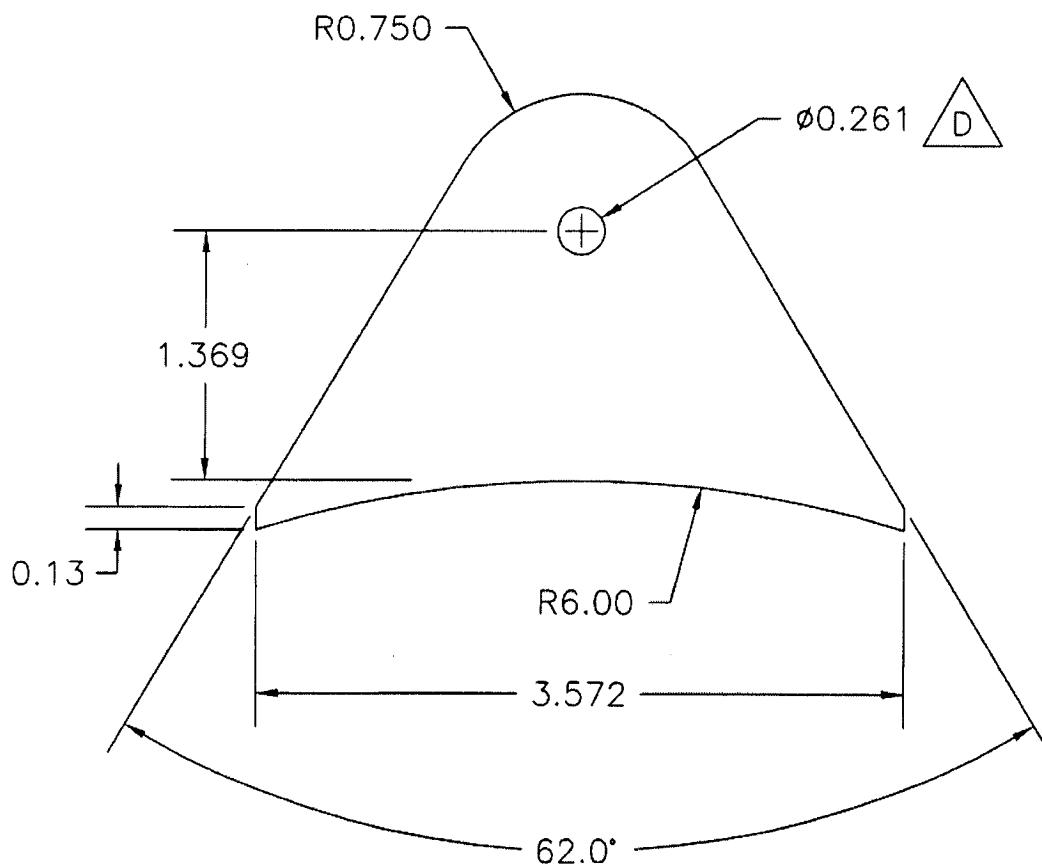
D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
 WELD PER DART QSI 004
 FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 ALL DIMENSIONS ARE IN INCHES
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

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 WITHOUT NOTICE
 WORK ORDER NO. 31609

DART

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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 KED2249-1 LUG

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MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN <i>RE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RE</i>	APPROVED <i>M</i>	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	REV. E SHEET 3 OF 4 SCALE 1:1

RELEASED

99.10.12 KE

4.44

B

Ø0.261 (TYP)



R0.125 (TYP)

R6.0

C

2.400

3.20

3.690

0.375 (TYP)

0.400 (TYP)

FLAT PATTERND2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

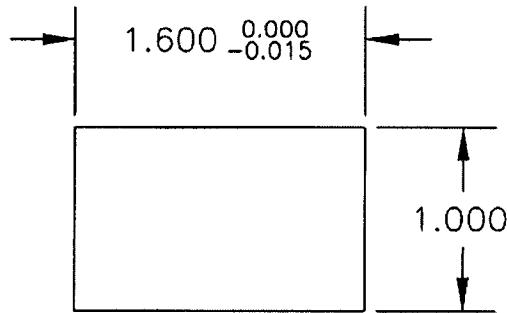
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BEND DETAIL

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WORK ORDER *31609*

DART

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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

RELEASED
99.10.12 KED2249-5 GUSSET

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WITHOUT NOTICE
WORK ORDER
NO. 31609

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED